

5/43

DART AEROSPACE LTD	Work Order:	24375
Description: 204/205 GHW Lug	Part Number:	D2736-3
Drawing: D2736 Rev. A	Qty:	40

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	AD	05.09.29	40
2	STORES	Pick: Qty Part Number Description Batch 1 D2591 Lug 324898 1 D2735-3 Lug Bracket 3216069	KE	06.01.26	40
3	WELDING	Weld as per QSI 004 and Dwg D2736 using locating Jig DT 8092-3	KE	06.01.27	40
4	QC	Inspect Level 5	AA	06/01/27	40
5	QC	Inspect Level 9	AA	06/01/27	40
6	FINISHING	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3	FC	06 02 08	40
7	QC	Inspect Level 3	U	6/2/9	40
8	STORES	Identify and Stock Luc 57149	U	6/2/9	40
9	EXPEDITING	Close W/O Cost / Part: 542 06/02/10 (40)	AD	06/02/10	40

Rev	Date	Change	Revised By	Approved
A	98.01.19	New Issue		BW
B	99.08.10	Reformat, add inspection level	EC	
C	00.06.06	Revised Step #6, in house powder coating	EC	

RELEASED

00.06.06

UNDER REVIEW

03.03.26 RF

Incorporated in 205-641-011

JUL 04.12.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 19 Date: 06/02/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Saturday, 11/5/2005 9:48:01 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 24375

Part Number: D27363

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



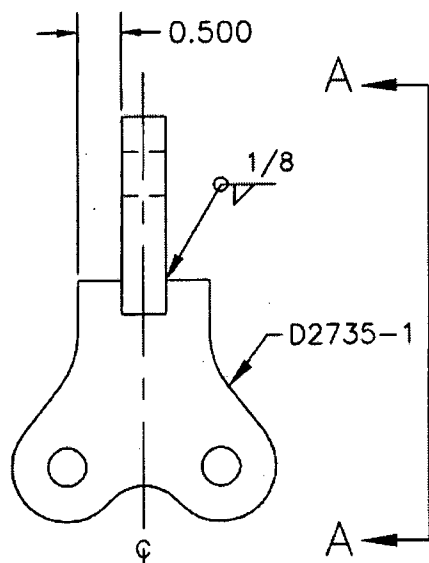
Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion

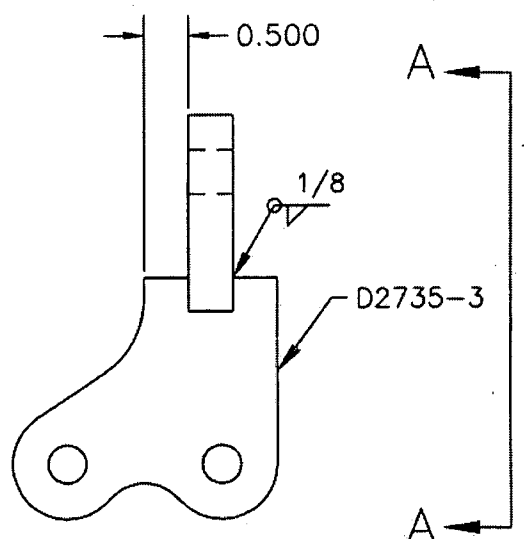




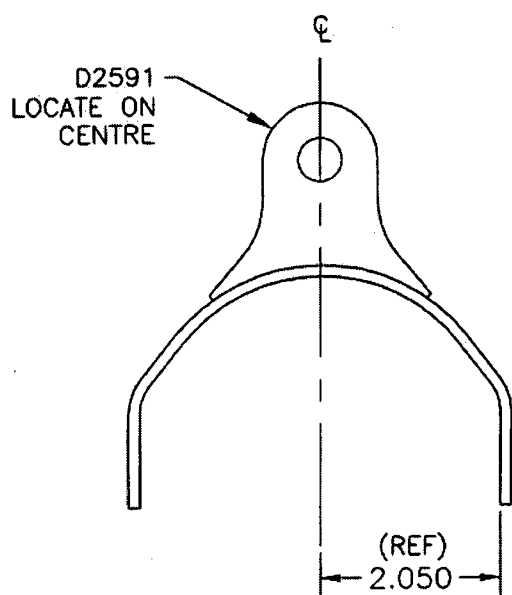
DESIGN <i>max</i>	DRAWN BY <i>max</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>RE</i>	APPROVED <i>GA</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

RETURN TO
ENGINEERING

UNCONTROLLED COPY

WFO ORDER
NO. 24375

RELEASED
97/12/24 DS

ECN 057

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 28, 2005
03:40 pm

Work Order No : 0024375
Project Name : D2736-3
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D2736-3
Description : Lug Assembly
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 09-28-05
Est Finish Date : 10-27-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:52 am

Work Order No : 0024375
Project Name : D2736-3
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D2736-3
Description : Lug Assembly
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 09-28-05
Est Finish Date : 10-27-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

MIS 013
11-11

Saturday, 11/5/2005 9:48:00 AM
Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG ASSEMBLY
Job Number :	24375		
Estimate Number :	10012		
P.O. Number :		Part Number :	D27363
This Issue :	11/5/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2736 REVA
First Issue :	/ /	Project Number :	
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	11/30/2005
Written By :		Qty:	40
Checked & Approved By :		Um:	Each
Comment :	Est Rev:D Removed from 9 digit 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2591	Lug
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2.0	D27353	Lug Bracket
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3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: _____

4.0	QC5/9	WELD INSPECTION
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**Comment:** WELD INSPECTION

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____